

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 162748***162748***

Page 2

Monday, June 12, 2017 11:35:46 AM

Item ID: SK145-0114-26 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Hook Pad
Start Date: 7/3/2017 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 7/7/2017 Req'd Qty: 5.00 ***5*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.50							
Quality Control									

17/7/10



JUL 10 2017

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Monday, June 12, 2017 11:35:58 AM

Page 1

Work Order ID: 162748

162748

Parent Item: SK145-0114-26

SK145-0114-26

Parent Item Name: Hook Pad

Start Date: 7/3/2017

Required Date: 7/7/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 17.06.06 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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8610K35		Purchased	No			100	sf	12.0000	0.21	1.105263			
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8610K35

Rubber Sheet

**

02/17/07/03

Location

Loc Qty

Loc Code

ST586A

12

m137748

12

1.3

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
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		OTHER : ☐																							

0114-

N/A
DAS
03
9-89
7-7-3

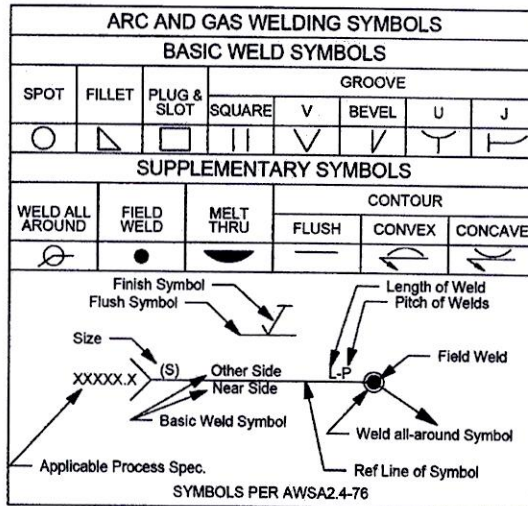
DAG
38
9-89

~~03 2017~~

H:\FORMS\Quality Assurance\approved QA\FAI revE

NOTES:

1. INTERPRET DRAWING IAW ASME Y14.100
2. UNLESS OTHERWISE SPECIFIED, HOLES INDICATED WITH 3 PLACE PRECISION (ϕ .XXX) TOLERANCED IN ACCORDANCE WITH ASME B4.1-1967 CLASS LC 11 (HOLE H13).
3. CALCULATED FASTENER LENGTHS SHOWN. ACTUAL FASTENER LENGTHS TO BE DETERMINED AT INSTALLATION.
4. FUSION WELDING IN ACCORDANCE WITH AWS D1731 CLASS A UNLESS OTHERWISE SPECIFIED.
5. FUSION WELDING INSPECTION TO BE ACCOMPLISHED VISUALLY.
6. POWDER COAT NON ID SURFACES, EXCEPT SURFACE OF ITEM 02 TO WHICH ITEM 26 WILL BE BONDED, USING IFC COATINGS CUSTOM YELLOW P747 PT. OVERSPRAY ACCEPTABLE.
7. IDENTIFY MANUFACTURED PARTS PER MIL-STD-130 AS FOLLOWS: [CAGEC] [PN] [REV].
EXAMPLE: 81205 1234567890-501 A
8. SCUFF THE BOTTOM OF ITEM 26 AND THE TOP OF ITEM 02 PRIOR TO ADHERING THEM TOGETHER
9. BOND ITEM 26 TO ITEM 02 USING ONE OF THE FOLLOWING:
 - ITEM 45
 - CA40 (3M)
 - ITEM 46 WITH ITEM 47
 IF CA40 OR ITEM 46 WITH ITEM 47 ARE USED, PRIME SURFACE WITH ITEM 48 IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS



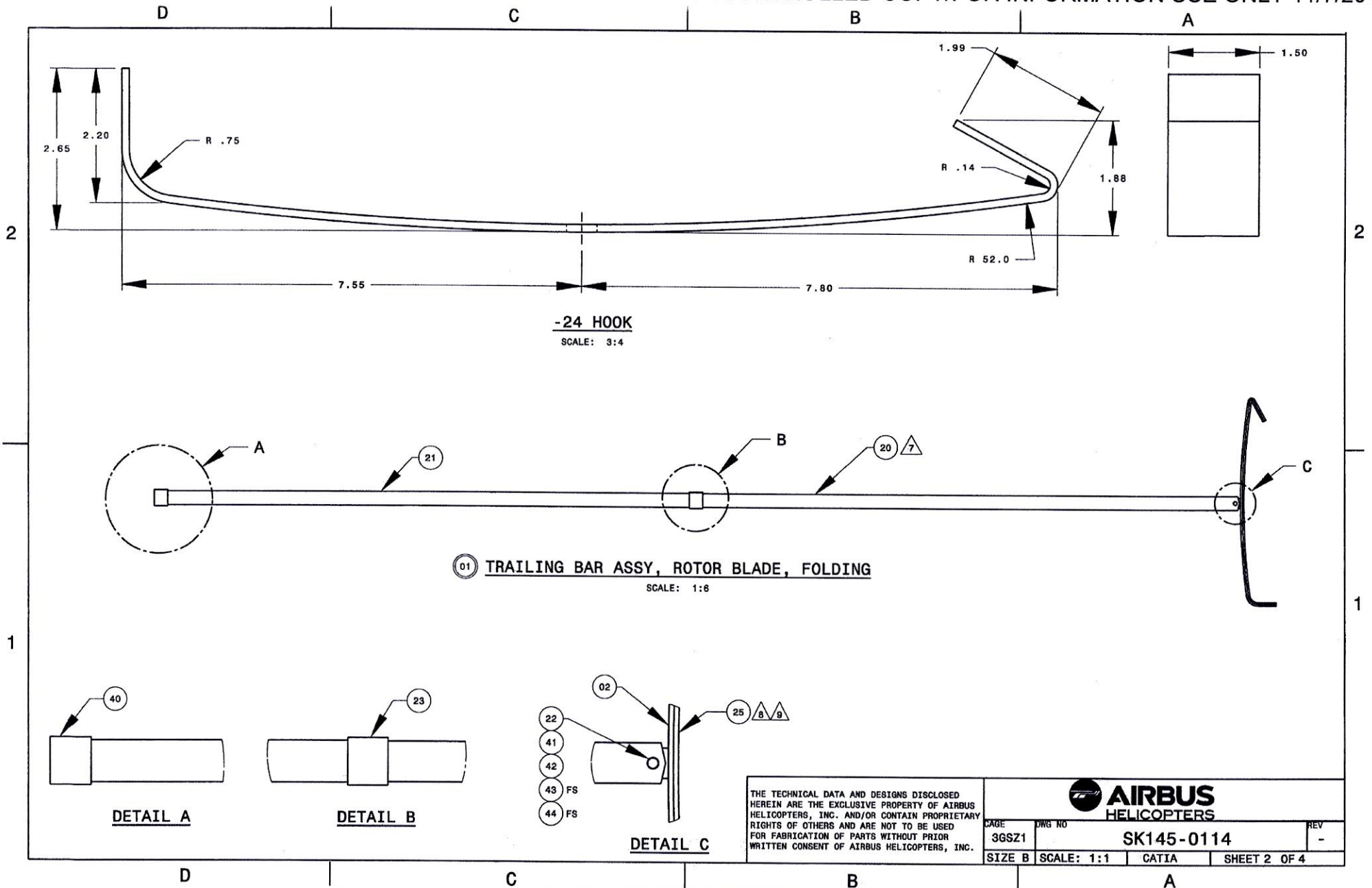
THE TECHNICAL DATA AND DESIGNS DISCLOSED HEREIN ARE THE EXCLUSIVE PROPERTY OF AIRBUS HELICOPTERS, INC. AND/OR CONTAIN PROPRIETARY RIGHTS OF OTHERS AND ARE NOT TO BE USED FOR FABRICATION OF PARTS WITHOUT PRIOR WRITTEN CONSENT OF AIRBUS HELICOPTERS, INC.

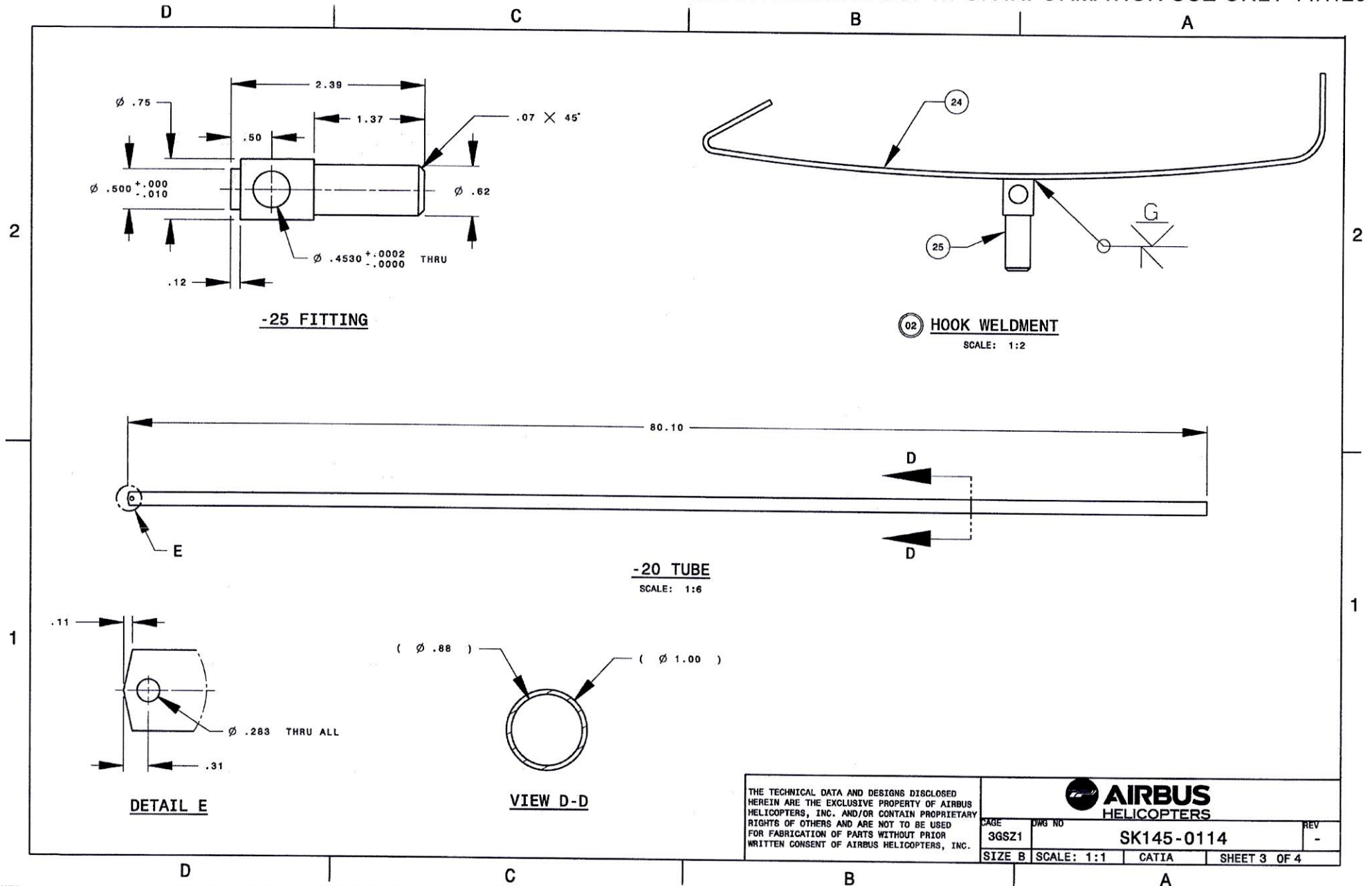
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1627424
JUN 12 2017

REVISION HISTORY			
SYM	DESCRIPTION	DATE	APPROVAL

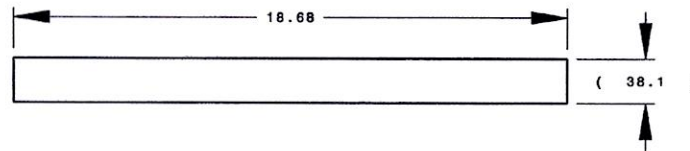
AR	48	PR200	METAL PRIMER	REMA		
AR	47	SC2000	CEMENT	REMA		
AR	46	UTR20	HARDENER	REMA		
AR	45	495	ADHESIVE	LOCTITE		
1	44	92198A111	BOLT	MTL SPEC		
1	43	NAS1149F0463P	WASHER	MTL SPEC		
1	42	MS3533B-44	WASHER	MTL SPEC		
1	41	MS21042L4	BOLT	MTL SPEC		
1	40	B4735K117	CAP	75A DIAPHRAGM, BLACK		
1	28		-28 HOOK PAD	EPDM		
1	25		-25 FITTING	A161 301 ANL AMS 5901		
1	24		-24 HOOK	HOT ROLLED STEEL SHEET	.125	
1	23		-23 COLLAR	B4735K117 CAGEC 30428		
1	22		-22 BUSHING	A161 301 ANL AMS 5901	Ø.438	
1	21		-21 GRIP	BLACK VEVID VINYL	1.5	
1	20		-20 TUBE	2024-TS AL ALY AMS-Q2-A-230/4	Ø1.000 X .080 WT	
	05					
	04					
	03					
	02		-02 HOOK WELDMENT			
	01		-01 TRAILING BAR ASSY. ROTOR BLADE, FOLDING	661K1891-105A		
-05	-04	-03	-02	-01	ITEM NO.	
QTY REQD					PART NUMBER	
					DESCRIPTION	
					MATL/SOURCE	
					STOCK SIZE	
					NOTES	

UNLESS OTHERWISE SPECIFIED, DIM ARE IN INCHES TOL ON ANGLES $\pm .5^\circ$ 1 PLACE $\pm .1$ 2 PLACE $\pm .03$ 3 PLACE $\pm .010$ INTERPRET DIM AND TOL PER ASME Y14.5-1994		DRAWING RELEASE ORDER 145-0981 NAME DATE ENGR MGR PROJ ENGR ENGR CK DRAFT CK DRAWN BY J. Lo Piccolo NEXT ASSEMBLY		 AIRBUS HELICOPTERS TITLE TRAILING BAR ASSY, ROTOR BLADE, FOLDING CAGE 3GSZ1 Dwg NO SK145-0114 SCALE: NONE CATIA SHEET 1 OF 4	
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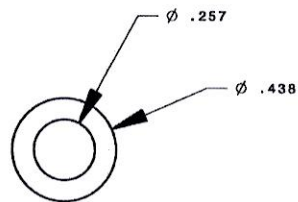
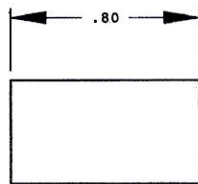




D C B A

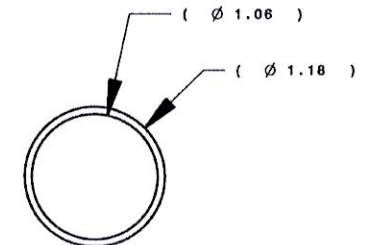
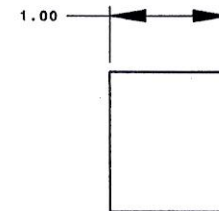


-26 HOOK PAD



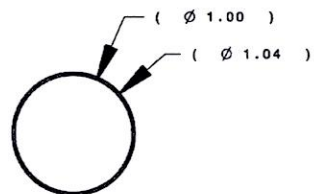
-22 BUSHING

SCALE: 2:1



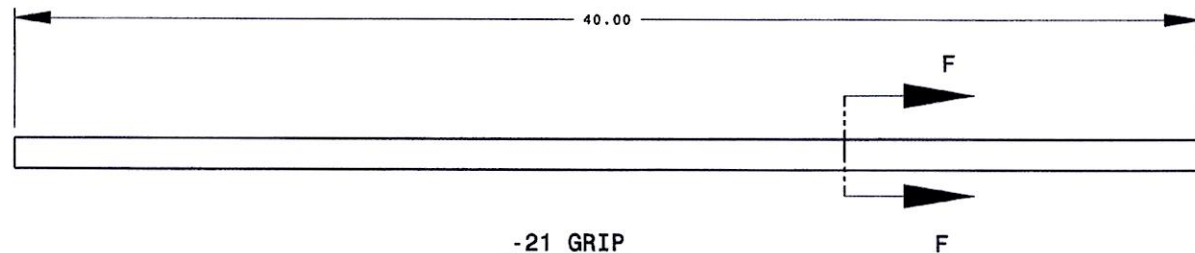
-23 COLLAR

SCALE: 1:1



VIEW F-F

SCALE: 1:1



-21 GRIP

D C B A

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PAGE 3GSZ1	DWG NO SK145-0114	REV -
SIZE B	SCALE: 1:4	CATIA
SHEET 4 OF 4		